

Work Order ID 150900

Monday, September 12, 2016 10:25:18 AM

150900

Page 1

Item ID: D350-1021-011

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Item Name: Safe Access Prop Rod

Stop ***NS2***

Start Date: 9/13/2016 Start Qty: 10.00

10

DAS
21
9-89

Cust Item ID:

Required Date: 9/15/2016 Req'd Qty: 10.00

10

Customer:

Reference:

Approvals:

Process Plan:

DAS
21
9-89

Date: SEP 12 2016

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr	Revision Nbr
IIN-D350-1021	A

OCT 24 2016

100

0.00

DAS
6
9-89

100

DOCUMENT CONTROL

DC

Memo

0.00

Doc.Control -USB or Paperwork

Photocopy bluefile & type labels per PPP D350-1021-011 CHG001

OCT 24 2016

110

Pick Kit

0.00

110

Packaging

Memo

0.00

Packaging

OCT 24 2016

DAS
28
9-89

120

QC4- 100% Inspect kits for completeness

0.00

120

QC

Memo

0.05

Quality Control

OCT 24 2016

DAS
27
9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : ☐					

Work Order ID 150900***150900***

Page 2

Monday, September 12, 2016 10:25:18 AM

Item ID: D350-1021-011**Accept*****N900040100*****Setup Start*****NS1*****Revision ID:****Stop*****NS2*****Item Name:** Safe Access Prop Rod**Start Date:** 9/13/2016 **Start Qty:** 10.00***10*****Cust Item ID:****Required Date:** 9/15/2016 **Req'd Qty:** 10.00***10*****Customer:****Reference:****Approvals:****Process Plan:** _____**Date:** _____**Tooling:** _____**Date:** _____**Run Start*****NR1*****QC:** _____**Date:** _____**SPC (Y/N):** _____**Date:** _____**Stop*****NR2*****Sequence ID/
Work Center ID****Operation
Description****Set Up/
Run Hours****Tool ID****Tool #****Plan
Code****Accept
Qty****Reject
Qty****Reject
Number****Insp.
Stamp**

130

0.00

130

Packaging

Packaging

Memo

0.00

Identify and pack for shipping as per PPP D350-1021-011

Location: _____

fs 018

1)

DAS
27
9-89

Packaging

OCT 24 2016

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Memo

0.17

Quality Control

16/10/26 JF

DAS
21
9-89

OCT 25 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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Picklist Print

Monday, September 12, 2016 10:25:23 AM

Page 1
[Signature]

Work Order ID: 150900

150900

Parent Item: D350-1021-011

D350-1021-011

Parent Item Name: Safe Access Prop Rod

Start Date: 9/13/2016

Required Date: 9/15/2016

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP REV:A 16.04.20 new issue DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN4-5 *AN4-5* BOLT		Purchased	No				Each	42.0000	1	10 11			DAS 28 9-89
OCT 24 2016													
				<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>				
				ST345			42						
				m134676			22						
				m135566			20						
D5311-041 *D5311-041* Engine Cowl Swing Prop Rod Assembly		Manufactured	No				Each	0.0000	1	10 11			DAS 28 9-89
OCT 24 2016													
D5418-1 *D5418-1* Placard		Manufactured	No				Each	52.0000	2	20 22			DAS 28 9-89
OCT 24 2016													
				<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>				
				ST168			52						
				146222			6						
				147081			2						
				150543			44						
AN310-4 *AN310-4* Nut		Purchased	No				Each	166.0000	1	10 11			DAS 28 9-89
OCT 24 2016													
				<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>				
				GA			25						
				M127815			25						
				OVER007			100						
				M135442			100						
				ST331			41						
				M134955			41						

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition			
2A1 2A2 2A3 2A4 2A5 2A6 2A7 2A8 2A9 2A10 2A11 2A12 2A13 2A14 2A15 2A16 2A17 2A18 2A19 2A20 2A21 2A22 2A23 2A24 2A25 2A26 2A27 2A28 2A29 2A30 2A31 2A32 2A33 2A34 2A35 2A36 2A37 2A38 2A39 2A40 2A41 2A42 2A43 2A44 2A45 2A46 2A47 2A48 2A49 2A50 2A51 2A52 2A53 2A54 2A55 2A56 2A57 2A58 2A59 2A60 2A61 2A62 2A63 2A64 2A65 2A66 2A67 2A68 2A69 2A70 2A71 2A72 2A73 2A74 2A75 2A76 2A77 2A78 2A79 2A80 2A81 2A82 2A83 2A84 2A85 2A86 2A87 2A88 2A89 2A90 2A91 2A92 2A93 2A94 2A95 2A96 2A97 2A98 2A99 2A100 2A101 2A102 2A103 2A104 2A105 2A106 2A107 2A108 2A109 2A110 2A111 2A112 2A113 2A114 2A115 2A116 2A117 2A118 2A119 2A120 2A121 2A122 2A123 2A124 2A125 2A126 2A127 2A128 2A129 2A130 2A131 2A132 2A133 2A134 2A135 2A136 2A137 2A138 2A139 2A140 2A141 2A142 2A143 2A144 2A145 2A146 2A147 2A148 2A149 2A150 2A151 2A152 2A153 2A154 2A155 2A156 2A157 2A158 2A159 2A160 2A161 2A162 2A163 2A164 2A165 2A166 2A167 2A168 2A169 2A170 2A171 2A172 2A173 2A174 2A175 2A176 2A177 2A178 2A179 2A180 2A181 2A182 2A183 2A184 2A185 2A186 2A187 2A188 2A189 2A190 2A191 2A192 2A193 2A194 2A195 2A196 2A197 2A198 2A199 2A200 2A201 2A202 2A203 2A204 2A205 2A206 2A207 2A208 2A209 2A210 2A211 2A212 2A213 2A214 2A215 2A216 2A217 2A218 2A219 2A220 2A221 2A222 2A223 2A224 2A225 2A226 2A227 2A228 2A229 2A230 2A231 2A232 2A233 2A234 2A235 2A236 2A237 2A238 2A239 2A240 2A241 2A242 2A243 2A244 2A245 2A246 2A247 2A248 2A249 2A250 2A251 2A252 2A253 2A254 2A255 2A256 2A257 2A258 2A259 2A260 2A261 2A262 2A263 2A264 2A265 2A266 2A267 2A268 2A269 2A270 2A271 2A272 2A273 2A274 2A275 2A276 2A277 2A278 2A279 2A280 2A281 2A282 2A283 2A284 2A285 2A286 2A287 2A288 2A289 2A290 2A291 2A292 2A293 2A294 2A295 2A296 2A297 2A298 2A299 2A300 2A301 2A302 2A303 2A304 2A305 2A306 2A307 2A308 2A309 2A310 2A311 2A312 2A313 2A314 2A315 2A316 2A317 2A318 2A319 2A320 2A321 2A322 2A323 2A324 2A325 2A326 2A327 2A328 2A329 2A330 2A331 2A332 2A333 2A334 2A335 2A336 2A337 2A338 2A339 2A340 2A341 2A342 2A343 2A344 2A345 2A346 2A347 2A348 2A349 2A350 2A351 2A352 2A353 2A354 2A355 2A356 2A357 2A358 2A359 2A360 2A361 2A362 2A363 2A364 2A365 2A366 2A367 2A368 2A369 2A370 2A371 2A372 2A373 2A374 2A375 2A376 2A377 2A378 2A379 2A380 2A381 2A382 2A383 2A384 2A385 2A386 2A387 2A388 2A389 2A390 2A391 2A392 2A393 2A394 2A395 2A396 2A397 2A398 2A399 2A400 2A401 2A402 2A403 2A404 2A405 2A406 2A407 2A408 2A409 2A410 2A411 2A412 2A413 2A414 2A415 2A416 2A417 2A418 2A419 2A420 2A421 2A422 2A423 2A424 2A425 2A426 2A427 2A428 2A429 2A430 2A431 2A432 2A433 2A434 2A435 2A436 2A437 2A438 2A439 2A440 2A441 2A442 2A443 2A444 2A445 2A446 2A447 2A448 2A449 2A450 2A451 2A452 2A453 2A454 2A455 2A456 2A457 2A458 2A459 2A460 2A461 2A462 2A463 2A464 2A465 2A466 2A467 2A468 2A469 2A470 2A471 2A472 2A473 2A474 2A475 2A476 2A477 2A478 2A479 2A480 2A481 2A482 2A483 2A484 2A485 2A486 2A487 2A488 2A489 2A490 2A491 2A492 2A493 2A494 2A495 2A496 2A497 2A498 2A499 2A500 2A501 2A502 2A503 2A504 2A505 2A506 2A507 2A508 2A509 2A510 2A511 2A512 2A513 2A514 2A515 2A516 2A517 2A518 2A519 2A520 2A521 2A522 2A523 2A524 2A525 2A526 2A527 2A528 2A529 2A530 2A531 2A532 2A533 2A534 2A535 2A536 2A537 2A538 2A539 2A540 2A541 2A542 2A543 2A544 2A545 2A546 2A547 2A548 2A549 2A550 2A551 2A552 2A553 2A554 2A555 2A556 2A557 2A558 2A559 2A560 2A561 2A562 2A563 2A564 2A565 2A566 2A567 2A568 2A569 2A570 2A571 2A572 2A573 2A574 2A575 2A576 2A577 2A578 2A579 2A580 2A581 2A582 2A583 2A584 2A585 2A586 2A587 2A588 2A589 2A590 2A591 2A592 2A593 2A594 2A595 2A596 2A597 2A598 2A599 2A600 2A601 2A602 2A603 2A604 2A605 2A606 2A607 2A608 2A609 2A610 2A611 2A612 2A613 2A614 2A615 2A616 2A617 2A618 2A619 2A620 2A621 2A622 2A623 2A624 2A625 2A626 2A627 2A628 2A629 2A630 2A631 2A632 2A633 2A634 2A635 2A636 2A637 2A638 2A639 2A640 2A641 2A642 2A643 2A644 2A645 2A646 2A647 2A648 2A649 2A650 2A651 2A652 2A653 2A654 2A655 2A656 2A657 2A658 2A659 2A660 2A661 2A662 2A663 2A664 2A665 2A666 2A667 2A668 2A669 2A670 2A671 2A672 2A673 2A674 2A675 2A676 2A677 2A678 2A679 2A680 2A681 2A682 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2A15					

Picklist Print

Monday, September 12, 2016 10:25:23 AM

Page 2

Work Order ID: 150900

150900

Parent Item: D350-1021-011

D350-1021-011

Parent Item Name: Safe Access Prop Rod

Start Date: 9/13/2016

Required Date: 9/15/2016

Start Qty: 10.00

Required Qty: 10.00

AN970-4

Purchased

No

Each

146.0000

2 20 22

AN970-4

Washer

**

OCT 24 2016

DAS

6

9-89

DAS

6

9-89

DAS
27
9-89

Location

Loc Qty

Loc Code

ST260a

100

m135390

50

m135600

50

ST321

46

m133769

45

m133992

1

Each

337.0000

10 11

**

OCT 24 2016

DAS

6

9-89

28

9-89

MS24665-155

Purchased

No

Each

337.0000

MS24665-155

Cotter Pin

DAS
27
9-89

Location

Loc Qty

Loc Code

ST289

337

m129163

337

11

Monday, September 12, 2016 10:25:23 AM

Shop Packet Print

Page 2

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS						
				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐			
				Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐			
				Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐			
				Large Fab ☐	Composite ☐	Supplier ☐				
Date : _____		Step #: _____		QTY Effective : _____			MRB (QSI042) Approval			
Description Work Order Deviation				Disposition						
				Completed By						
				Lead hand / Supervisor Approval Verification						
				QC / QA Coordinator Approval						
Root Cause		FAULT CATEGORY								
Environment ☐	☐	No Re-verification ☐	☐	Pressure/Forced ☐	☐	Temperature/Cure ☐	☐	Power Loss/Surge ☐	☐	Positioned Wrong ☐
Design ☐	☐	Operator ☐	☐	Bending ☐	☐	Set-up ☐	☐	Folio/Program ☐	☐	Outside Dimensions ☐
Doc/Data ☐	☐	Offset/Setup ☐	☐	Centre Not Concentric ☐	☐	BOM/Route ☐	☐	Grain ☐	☐	Over/Under tolerance ☐
Equip/Tooling ☐	☐	Supplier ☐	☐	Cracks ☐	☐	Broken/Damage/Defect ☐	☐	Weld ☐	☐	Part Incorrect ☐
Handling/Pre ☐	☐	Training ☐	☐	Crimp/Kink/Ripple/Wave ☐	☐	Inspection Incomplete/Unqualified ☐	☐	Wrong Stock Pulled ☐	☐	Part Lost/Missing ☐
Material ☐	☐	Use for Testing ☐	☐	Cuffs ☐	☐	Contamination ☐	☐	Out of Sequence ☐	☐	Part Moved ☐
Internal Transport ☐	☐	Poor Information ☐	☐	Crushing ☐	☐	Countersink ☐	☐	Off-set ☐	☐	Drawing ☐
Tribal Knowledge ☐	☐	Rushing ☐	☐	Heat Treat ☐	☐	Cut Too Short ☐	☐	Mislabeled ☐	☐	Finish ☐
LOA ☐	☐	Product Improvement ☐	☐	Wave/Twist in Tube ☐	☐	Instructions Incomplete/Unclear ☐	☐	Fit/Function ☐	☐	Misread ☐
Substation ☐	☐	Process Improvement ☐	☐	Marks/Chatter ☐	☐	Drill Holes ☐	☐	Misaligned/off center ☐	☐	Turning Sequence ☐
Past Expiry Date ☐	☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	☐	Past Due ☐								

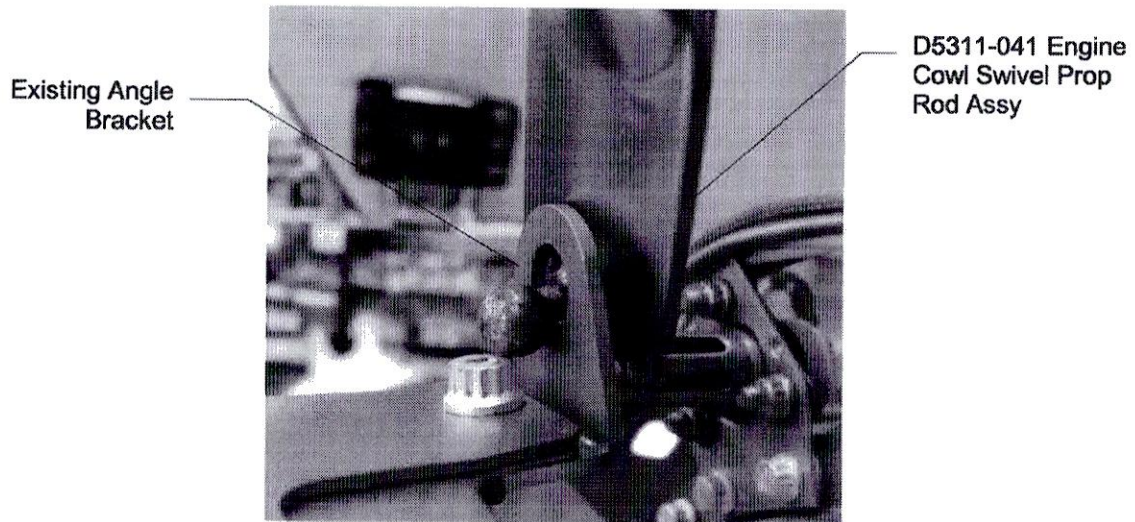


Figure 5: Alternate Prop Rod Mounting Location

4.0 WEIGHT AND BALANCE

The following table shows the net weight increase associated with the D350-1021-011 Engine Cowl Swivel Prop Rod kit.

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D350-1021-011 Engine Cowl Swivel Prop Rod Kit	0.6 lb 0.3 kg	+12.0 in +0.3 m	+7.2 in-lb +0.1 m-kg	163.4 in 4.2 m	98 in-lb 1.3 m-kg

5.0 PARTS LIST

Qty -011	Part Number	Description
X	D350-1021-011	ENGINE COWL SWIVEL PROP ROD KIT
1	D5311-041	ENGINE COWL SWIVEL PROP ROD ASSEMBLY
1*	D3622-15	BALL STUD
2	D5418-1	PLACARD
1	AN310-4	NUT, CASTELLATED
1	AN4-5	BOLT
2	AN970-4	WASHER
1	MS24665-155	COTTER PIN
1*	LN9016-06K	WASHER (ALT: LN9016-06L, 23116TK060X)
1*	LN9161-06M	NUT (ALT: ASN52320BH060N)

* PART INCLUDED IN D5311-041 ASSEMBLY

Work Order ID 150900***150900***

Page 1

Monday, October 24, 2016 8:13:53 AM

Item ID: D350-1021-011

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Safe Access Prop Rod

Start Date: 9/13/2016 Start Qty: 1.00

1

Cust Item ID:

Required Date: 9/15/2016 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

NR1

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
----------	--------------

IIN-D350-1021

A

DAS
21
9-29

OCT 24 2016

100

0.00

100

DOCUMENT CONTROL

DC

Memo

0.00

Doc.Control -USB or Paperwork

Photocopy bluefile & type labels per PPP D350-1021-011 CHG001

DAS
21
9-29

OCT 24 2016

110

Pick Kit

0.00

110

Packaging

Memo

0.00

Packaging

120

QC4- 100% Inspect kits for completeness

0.00

120

QC

Memo

0.01

Quality Control